: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Thursday, 11/23/2006 11:53:06 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number : 29660

Estimate Number

: 10530

P.O. Number This Issue

: N/A : 11/23/2006

MA

: 29510

S.O. No. : NIA

Type

: MACHINED PARTS

Part Number

Drawing Name

Drawing Number

: D2571 . D2571 REV E

: N/A

Project Number

Drawing Revision : NIA Material

Due Date : 12/23/2006 Qty:

12 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By

Comment

Re-format; Change to Dwg Rev. D &

incorporated D2572KJ

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.:

1.0000 Each(s)/Unit

12.0000 Each(s)

Total:

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: 895 35 3

po6/4/25

2.0

HAAS1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 82966 Double check by: 5.6

06/11/29

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

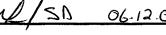
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

3.0

CONVENTIONAL MILLING MACHINE



MILLING CONV

Comment: CONVENTIONAL MILLING MACHINE ::

Machine keyway as per dwg D2571 & D2572



4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:	•	WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
•							
						:	
			-				
Part No		PAR #: Fault Category:	NCR: Yes	No. DQA		<u>∄</u> Date: _∂	6/12/19

Part No:	PAR #:	Fault Category:	NCR: Yes (No) DQA:	Date: <u>かん/み//</u> を
			QA: N/C Closed:	Date:

NCR:		\	VORK ORD	DER NON-CONFORMANC	E (NCR)						
		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
				·							
				•							
						. **					

NOTE: Date & initial all entries

	ursday, 11/23/2006 11:53:06 AM		
User: Kir	n Johnston	Process Sheet	
Customer	r: CU-DAR001 Dart Helicopters Services	Drawing Name: SADDLE	FITTING, FWD (OUTBOARD/INBOARD)
Job Number	r: 29660	Part Number: D2571	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK	
	nent: SECOND CHECK		J.L 06//2/10 12
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comm	nent: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4	.1 O. A. O.	/12/18 (12)
7.0	POWDER COATING Market	POWDER COATING MIO239/	
Comm	nent: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1)	as per QSI 005 4.3 <i>M-A</i>	E 06/12/18 (2)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CO	
	nent: INSPECT POWDER COAT	16.6/119	
9.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Identify and Stock Location: S + 978	Du 4/1.	1/5 (2)
10.0	QC21	FINAL·INSPECTION/W/O RELEASE	
Comm	nent: FINAL INSPECTION/W/O RELEASE		49 06/12/19
Job Completion	C.	Job 112119	
•			

Dart Ae	rospace	Ltd						·	
W/O:			WC	ORK ORDER CHANG	ES				-c.
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A :	Date:	
			•		QA: N	/C Close	d:	_ Date: _	
NCR:		,	WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)			
		Description of NC		Corrective Action Section	on B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
							!		
				and the second s					

		Description of NC		Corrective Action Section B		Verification Approval		Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
						-		
1				·				
								·

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29660
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Re	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT868 2	8.440	o.mo	0.440	0.440		
В	1.745	1.755		1.756	1.750	1.749	1.750		
С	3.495	3.505		3,500	3,500		3.500		
D	1.745	1.755		1.350	1.750	1.749	1.750		
Е	7.990	8.010		7.999	7.999	2.999	7.999		
F	0.490	0.510		0.505		0,503	0,505		
G	0.257	0.262	DT8683	0.257	0.250	0.258	0.258		
Н	0.375	0.380	DT8684	0377	0.377	0.377	0.377		
1	0.490	0.510		0.500	0.501	0.500	0.500		
J	1.174	1.184		1.178	1.7.78	1.178	1.178		
K	0.558	0.578		0.5.66	0.567	0.568	0567		
L	1.174	1.184		1.178	1.173	1.178	1.178		
М	1.490	1.500		1.494	1.494	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2,500		
0	3.869	3.879		3,872	3.871	3.871	3.871		
Р	0.115	0.135		0.127	0.127	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0:135	0:135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.129	0.129	0.129	0.129		
T	0.178	0.198		0.188	0.188	0.188	0/88		
U	2.940	2.980		2.960	2.960 0.238	2966	2.960		
V	0.230	0.250		0,241	0.238	0.246			
W	0.115	0.135		0.122	0.1.21	0.122	0.122		
Χ	0.308	0.313		0.312	0.312	0.311	0.312		
Υ	0.760	0.765		0.765	0.765	0 765	0.765		
Z	0.352	0.372		0.364	0.765	0.366	0.366		
AA	0.470	0.530		6500	8.500	0.500	0500		
AB	0.615	0.635		0.635	0.635	0.635	0.635		
AC	0.053	0.073		0063	0.063	0063	0.063		
AD _	0.240	0.260		0.248	0.246	0.247	0.247		
AE	1.375	1.395	•	1.387	1.389	1.388	1.388		
AF	0.115	0.135		6.135	0135	6135	0.247		
AG	0.240	0.280		0.760	0.266	0.260	0.260		
AH	0.240	0.260		0.249	6.242	0.247			
ΑI	2.000	2.020		2.002	2.003	2,002	2.003		
AJ	0.023	0.043		0030	0.030	0.030	0 030		
	Acc	ept/Reje	ct				_		

Measured by:	and.	Audited by	ブ. レ
Date:	06/12/01	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	-1
Е	05.12.05	Added dimension AJ	KJ/JLM	Cull.

DART AEROSPACE LTD	Work Order:	29660
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Red	corded Actu	ual Dimensi	ons		
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.438	0.443	DT8682	0.446	439	,4/39	439		
В	1.745	1.755		1.749	1,749	1.758	.1.758		
С	3.495	3.505		3.499	3500	3,508	3,400		
D	1.745	1.755		1.749	1,749	1.748	1.750		
E	7.990	8.010		2.999	72999	7.999	ass. 11		
F	0.490	0.510		0.504	.500	483	1496		
G	0.257	0.262	DT8683	0.258	1258	-258	,258		
H	0.375	0.380	DT8684	4.372	376	-316	,376		
1	0.490	0.510		6.506	-508	,499	1499		
J	1.174	1.184		1.173	1-179	1.175	1,179		
K	0.558	0.578		0,568	.570	:573	.569		
L	1.174	1.184		1.178	1.179	1.175	1173		
М	1.490	1.500		1.495	1.495	1.495	1,495		
N	2.495	2.505		2,500	2.500	2500	2500		
0	3.869	3.879		3.871	3.814	3.873	3-873		
Р	0.115	0.135		0.127	126	-127	127		
Q	0.115	0.135		0.135	135	.135	135		
R	0.240	0.260		0,251	-2505	251	.251		
S	0.115	0.135		6.130	127	1128	1127		
Т	0.178	0.198		0,188	- /88	188	188		
U	2.940	2.980	.,	2.460	2960	2-966	2,960		
V	0.230	0.250		0.234	-238	-237	234		
W	0.115	0.135		0.123	. 122	123	123		
Χ	0.308	0.313		0.312	. 3/3	-3/3	-3/3		
Υ	0.760	0.765		0.761	762	782	-313 -762		
Z	0.352	0.372		0.365	.362	.363	.362		
AA	0.470	0.530		0.500	500	,500	.500		
AB	0.615	0.635	,,,	0.635	, 630	7637	-632		
AC	0.053	0.073		0.063	1063	-663	063		
AD	0.240	0.260		0,245	.248	1250			
AE	1.375	1.395		1.389	1.389	1.389	250		
AF	0.115	0.135		0.133	137	134	.136		
AG	0.240	0.280		0,250	-250	-238	.20D		
AH	0.240	0.260		0.247	248	246	1276		
ΑI	2.000	2.020		2.004	2.003	2.004	2004		
AJ	0.023	0.043	· · · · · · · · · · · · · · · · · · ·	0.030	.030	203	1030		
		ept/Reje	ct		30	-			-

Measured by:	and/SD	Audited by	J.L
Date:	06.12.63	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
Α		New Issue *	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	-1
Е	05.12.05	Added dimension AJ	KJ/JLM 🚜	911

DART AEROSPACE LTD	Work Order:	2660
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

		Recorded Actual Dimen				Recorded Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date	
Α	0.438	0.443	DT8682	1439	.435	,439	.439			
В	1.745	1.755		1.748	1.750	1.749	1.750			
С	3.495	3.505		3,500	3.400	3,500	3.500			
D	1.745	1.755		1.750	1,700	1750	1.748			
E	7.990	8.010		7,797	7,999	N-030	7.999			
F	0.490	0.510		.498	.496	,487	-495			
G	0.257	0.262	DT8683	1758	-258	-228	258			
Н	0.375	0.380	DT8684	316	.376	376	376			
	0.490	0.510		102.	.376	376	-4A8			
J	1.174	1.184		1179	1179	1.179	4173			
K	0.558	0.578		.566	567	~566	1.148			
L	1.174	1.184		1.178	1.178	1179	1.179			
М	1.490	1.500		1495	1,483	1,495	1.495			
N	2.495	2.505		2,500	1,300°	2,500	2.500			
0	3.869	3.879		3,874	3.874	3.874	3.874			
Р	0.115	0.135		1,124	.127	1127	-126			
Q	0.115	0.135		.135	. / 35	.135	-136			
R	0.240	0.260		-25L	-251	250	-251			
S	0.115	0.135		·/28	-127	.127	-128			
Т	0.178	0.198		-188	.188	-188	188			
U	2.940	2.980		2.560	2,560	2.960	2.960			
V	0.230	0.250		-240	241	-241	.241			
W	0.115	0.135		.126	123	.121	121			
Χ	0.308	0.313		. 312 -	.312	~3 i2	313			
Υ	0.760	0.765		.761	.761	-761	761			
Z	0.352	0.372		. 363	.364	-364	.363			
AA	0.470	0.530		G02.	2500	,500	1500			
AB	0.615	0.635		626	-626	.628	.627			
AC	0.053	0.073		.063	- OG 3	-063	-063			
AD	0.240	0.260		1250	1.390	1250	25-1			
ΑE	1.375	1.395		1.385	1.390	1390	1321			
AF	0.115	0.135		134	133	.135	135			
AG	0.240	0.280		.250	-250	-250	250			
AH	0.240	0.260		.248	1278	-247	246.		·	
ΑI	2.000	2.020		2.003	2.004	2.004	2.00Z			
AJ	0.023	0.043		6.030	0.030	0.030	0.030			
-	Acc	ept/Reje	ct							

Measured by:	27	Audited by	J.L.	
Date:	06.12-02	Date:	06/12/10	

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.09.24	Re-format; Added Rev. D	KJ	
С	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension Al	KJ/RF	-1
Ε	05.12.05	Added dimension AJ	KJ/JLM 🚓	

4.000 1.495±0.005 - 3.874±0.005 R0.57 (TYP) 00.375^{+0.005} (TYP 2 PLACES 0.125 RIDGE RELEASED 0.568 0.500 05.12.d \$ Α 1.179 ±0.005 **NOTES** Ø0.750 (TYP) R0.75 (TYP) -**D** MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 - 2.500 Ø0.510 MIN Ø0.257^{+0.005} POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART ±0.005 FLAT AROUND ALL HOLES R0.50 -QSI 005 4.3 (TYP 8 PLACES) ±0.005 R0.50 -BREAK ALL SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5.500 RO.063 -1.495±0.005 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 R0.38 (TYP) 0.125 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 RIDGE WITH MIN RAD 0.125 0.25±0.03 RIDGE GRAIN 0.125 DIRECTION R2.000±8.880 CHAMFER 0.063" x 45" AROUND THIS SURFACE (TYPICAL 2 PLACES) R0.50 (TYP) -CHAMFER 0.063" x 45' ALL AROUND R0.50 CHAMFER 0.033" x 45" (SEE DETAIL C) 0.313_0.000 /E\ R0.025 В (TYP) R0.063 (TYP) 0.760+0.005 DA CET VIEW B-B RO.66 (TYP) 0.362 R0.50 2.050+0.005 (TYP) DETAIL C - 0.20 1.250 2.960±0.020 -R0.50 (TYP) - 0.750 \oplus DAV3T 0.250 0.240 FLAT ON RIDGE 0.250 #0.438^{+0.005} -(TYP 4 PLACES) (TYP ALL RIDGES) R0.50 (TYP) R0.50 (TYP) 1.750 ±0.005 1.750 0.500 - 3.500±0.005 0.060 1.573 8.000 RO.188 (TYP AROUND POCKET) (REF) 0.125 05.07.13 ADD CHAMFER ON RIDGE, NOTE 5 R1.385 0.063 (TYP) D 02.09.06 ADD RIDGES; TIGHTEN TOLERANCES INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177 0.125 0.250 C 99.10.22 В 96.12.02 ADD GRAIN DIR., 0.438 WAS 0.425 SECTION A-A R0.025 Α 96.09.16 NEW ISSUE SHOP COPY (REF, TYP) DART AEROSPACE LTD. DART RETURN TO COPYRIGHT @ 2008 BY DART AEROSPACE LTD. DS PH DETAIL C THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION. THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. ENGINEERIN'G SCALE 4:3 D2571 SHEET 1 OF **UNCONTROLLED COPY** DATE 05.07.13 OUTER FWD SADDLE SUBJECT TO AMENDMENT WITHOUT NOTICE